

Date: Tuesday, 19/08/2008 4:07:35 PM  
 User: Julie Lecocq

## Process Sheet

|                       |  |          |                  |                  |                            |  |  |
|-----------------------|--|----------|------------------|------------------|----------------------------|--|--|
| Customer              | : CU-DAR001 Dart Helicopters Services            |          |                  | Drawing Name     | : UPPER BLADE SUPPORT ASSY |  |  |
| Job Number            | : 41514  |          |                  | Part Number      | : PB674300175              |  |  |
| Estimate Number       | : 13471  |          |                  | Drawing Number   | : B6743001 P.11            |  |  |
| P.O. Number           | :  |          |                  | Project Number   | : N/A                      |  |  |
| This Issue            | : 19/08/2008                                     | S.O. No. | :                | Drawing Revision | : B1                       |  |  |
| Prsh Rev.             | : NC   |          |                  | Material         | :                          |  |  |
| First Issue           | : / /  | Type     | : LARGE FAB ASSY | Due Date         | : 18/09/2008               |  |  |
| Previous Run          | : 40597  |          |                  | Qty:             | 800                        |  |  |
| Written By            | :  |          |                  | Um:              | Each                       |  |  |
| Checked & Approved By | : <u>Julie Lecocq</u>                            |          |                  |                  |                            |  |  |
| Comment               | : Est Rev:A 08-07-17 new issue DD verified by:ec |          |                  |                  |                            |  |  |

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description :   |                 |
|---------|-----------------------|---|-----------------|
| 1.0     | PB6743001167          | Long Side Plate   | 16              |
|         |                       |   |                 |
|         |                       | Comment: Qty.: 2.0000 Each(s)/Unit Total : 60.0000 Each(s)  |                 |
|         |                       | Long Side Plate   |                 |
|         |                       | batch: <u>340028 = 16</u> * <u>341561 = 2</u>               | <u>08.10.01</u> |
| 2.0     | PB6743001169          | Long Support Plate  | 8               |
|         |                       |   |                 |
|         |                       | Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)  |                 |
|         |                       | Long Support Plate  |                 |
|         |                       | batch: <u>341562</u> ST                                     | <u>08.10.01</u> |
| 3.0     | PB6743001171          | Mounting Plate  | 48              |
|         |                       |   |                 |
|         |                       | Comment: Qty.: 6.0000 Each(s)/Unit Total : 180.0000 Each(s) |                 |
|         |                       | Mounting Plate  |                 |
|         |                       | batch: <u>338103</u> ST - metec                             | <u>08.10.01</u> |
| 4.0     | D34501                | Reinforcement Plate   | 8               |
|         |                       |   |                 |
|         |                       | Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)  |                 |
|         |                       | Reinforcement Plate   |                 |
|         |                       | batch: <u>339954</u> ST                                     | <u>08.10.01</u> |
| 5.0     | LARGE FAB 1           | LARGE FABRICATION RESOURCE 1                                | 8               |
|         |                       |   |                 |
|         |                       | Comment: Weld assembly as per dwg PB67-43001                | <u>08.10.02</u> |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 4:07:35 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UPPER BLADE SUPPORT ASSY

Job Number: 41514

Part Number: PB674300175

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08/10/02



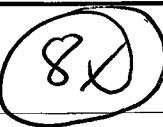
7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/02

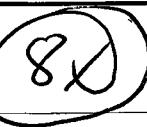


8.0 POWDER COATING

POWDER COATING



M 10 2316



Comment: POWDER COATING

1- put screws in nut plates before powder coating to keep thread clean

2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

3:15

OVEN TEMPERATURE:

320<sup>0</sup>F

FINISH TIME:

3:45

M 10 08/10/03

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ 08/10/03



10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 510

AS 08/10/06



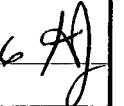
11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/06



Job Completion



U 8/10/06

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

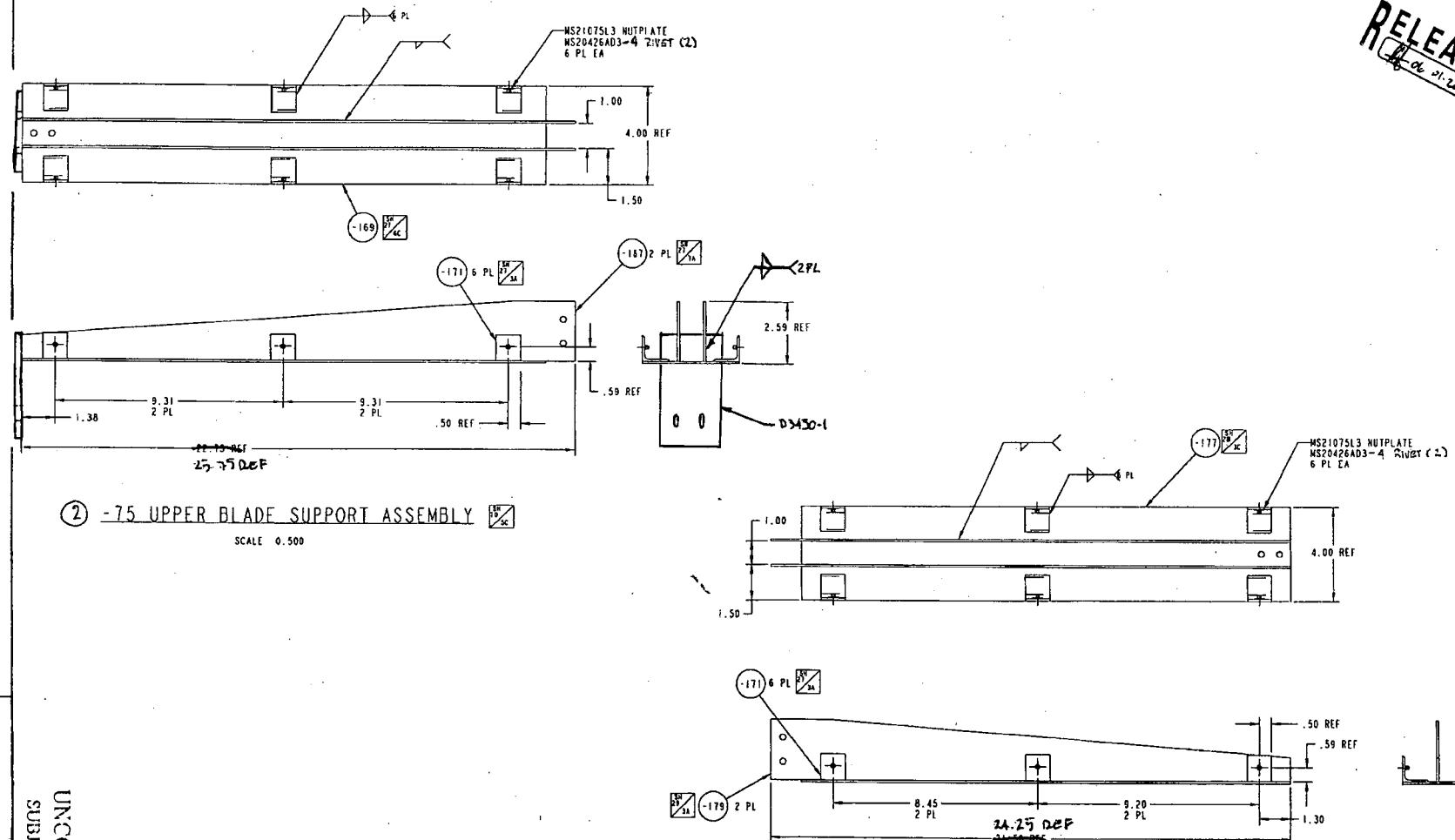
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

8 | 7 | 6 | 5 | 4 | 3 | 2 |

RELEASED  
06-01-20



② -79 LOWER BLADE SUPPORT ASSEMBLY

SCALE 0.500

|   |                   |           |          |
|---|-------------------|-----------|----------|
| PREMIER AVIATION, INC.                            |                   |           |          |
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| SAFETY  | COPIES IDENT. NO. | ORG. NO.  | REV.     |
| D   | DOSUV8            | B67-43001 | 81       |
| SCALE   | 1:1               | ENCL      | 11 of 45 |

**ORIGINAL**

RETURN TO  
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